

Guide Bush

Oilless Plain Type

Die Guide Components

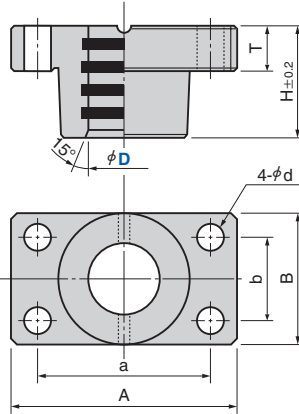


Mounting bolts (4) and dowels (2) are attached.

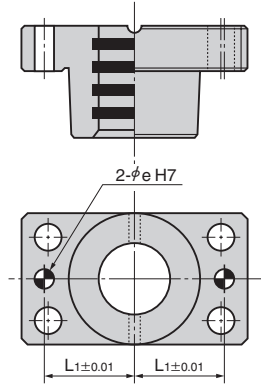
● Accessories

D	Bolt	Dowel
25	M8x35	φ 8x30
32	M10x40	
38	M10x45	φ 10x40
50	M12x50	
60	M16x60	φ 13x50
80	M20x75	φ 16x60

SGRB



SGRBN (With dowel hole)



〈Material〉 SO#50F

Catalog No.	D	Tolerance	A	a	B	b	H	T	d	L ₁	e	H7
SGRB	25	+0.041 +0.031	84	66	48	30	45	20	9	33	8	+0.015 0
	32	+0.047 +0.037	100	76	58	36	50		11	38		
	38	+0.049 +0.037	130	100	75	44	60	25	50	10		
SGRBN	50	+0.052 +0.037	155	125	90	60	85	30	14	62.5	13	+0.018 0
	60	+0.061 +0.043	190	150	120	80	100		18	75		
	80	+0.063 +0.043	230	180	150	110	130		35	22		



Order

Catalog No.	D	Option
SGRB	38	
SGRB	38	- W



Option

Option Code	Specification
W	Tapped hole for the height block is drilled on the guide bushing.
BM	Tapped hole for lifting bolt is drilled on the guide bushing. (D=25~50 only)
RB	Guide bushing is changed to the inverted mounting type.

Refer to page 69~70 for option details.

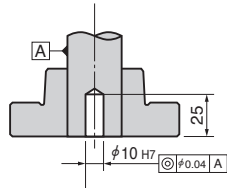
Die Guide Components

Option

Die Guide Components

■Drilling of Center Dowel Hole

—C

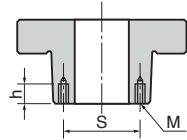


—C

Dowel hole for location is drilled at the center of the guide post.

■Drilling of Height Block Mounting Tapped Hole

—W



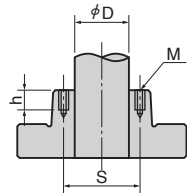
—W

Tapped hole for height block mounting is drilled on the guide bushing.

—M (φ 25, φ 32)

Tapped hole for height block mounting is drilled on the guide holder.

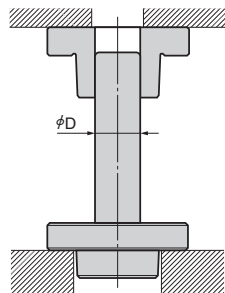
—M



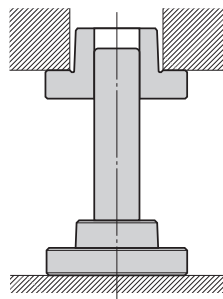
D	M	h	S
25	4	12	37
32	4	12	45
38	5	15	60
50	6	15	72
60	8	20	92
80	8	20	116

■Machining of Reverse Holder and Bushing Type

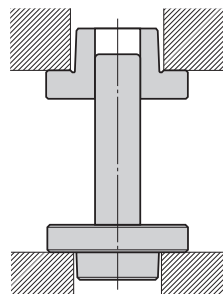
—RH



—RB



—RHB



—RH

The flange surface of the guide holder is machined flat for inverted mounting type.

—RB

The flange surface of the guide bushing is machined flat for inverted mounting type.

—RHB

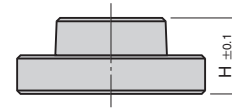
Both the guide holder and the guide bushing are inverted mounting type.

● Dimension that can reduce die height

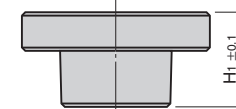
D	RH	RB
25	10	25
32	20	30
38	25	35
50	40	60
60	45	70
80	65	95

■Precision Machining of Holder and Bushing Height

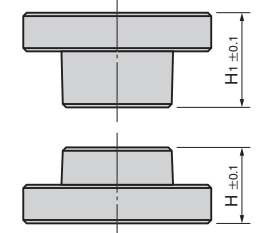
—HK



—BK



—HBK



—HK

The guide holder height is precision machined to ± 0.1

—BK

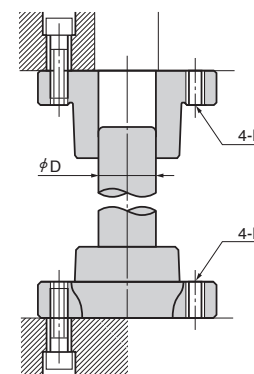
The guide bushing height is precision machined to ± 0.1

—HBK

Both the guide holder and the guide bushing height are precision machined to ± 0.1

■Drilling of Mounting Bolt Tapped Hole (φ 25, φ 32, φ 38, φ 50)

—BM



—BM

Tapped hole for lifting bolt is drilled on the guide bushing.

—HM

Tapped hole for pulling bolt is drilled on the guide holder.

D	M
25	8
32·38	10
50	12

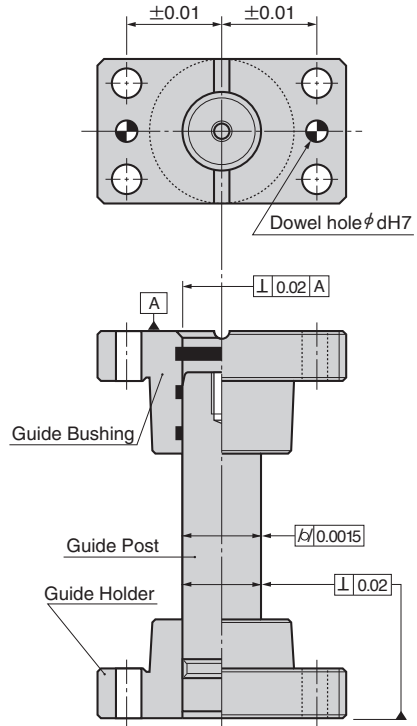
—HM

Guide Post Set [Overview]

Die Guide Components

■ Guide Post Set Accuracy

The accuracy of Guide Post is important as it can significantly affect the life expectancy of dies and products stamped by the dies. Our Guide Post Sets are manufactured to precision under strict control system as shown below:



■ Product Accuracy

	Guide Bushing	Guide Post	Guide Holder
Roundness	Within 1μ	Within 1μ	—
Concentricity	Within 2μ	Within 1.5μ	—
Surface roughness	0.4a	0.2a	0.4a
Assembly squareness	0.02/100 mm Squareness between guide bushing bottom surface and guide post center		—
	—	0.02/100 mm Squareness between guide holder bottom surface and guide post center	